

CLAIMS

1. Method for manufacturing sheets of agglomerate material comprising, in succession, a first step involving preparation of a mix by mixing together stone materials of predetermined particle size with a binder consisting of organic resins, a second step involving distribution of said mix inside a tray mould so as to form a layer of mix, a third step involving vacuum vibro-compaction in order to obtain a compacted sheet, and a final step involving hardening or catalysis of the binder by means of heating ovens in order to obtain the finished products, characterized in that an intermediate step involving dielectric preheating of the compacted sheet is introduced between said third vacuum vibro-compaction step and said final hardening step.
2. Method according to Claim 1, characterized in that said intermediate step involving dielectric preheating of the compacted sheet is performed by means of heating with electromagnetic radiofrequency waves having a frequency of less than 300 MHz.
3. Method according to Claim 2, characterized in that said radiofrequency waves have a frequency ranging between 25 and 35 MHz.
4. Method according to any one of the preceding claims, characterized in that, during the said intermediate preheating step, the compacted sheet reaches a temperature lower than the temperature at which catalysis of the binder starts and preferably ranging between 75°C and 78°C.
5. Method according to any one of the preceding claims, characterized in that it may be used for a mix which contains granulates of the expanded type.
6. Plant for manufacturing sheets of agglomerate material using the method according to any one of the preceding claims and comprising, in succession, a first station (20) for preparing a mix by mixing a granulate of predetermined particle size with a binder consisting of organic resins, a second station (30) for distributing said mix inside a tray mould (12) so as to form a layer of mix, a third vacuum vibro-compaction station (40) for obtaining a compacted sheet, and a final hardening station (60) comprising at least one heating oven for catalysis of the organic binder so as to obtain the final sheet, characterized in that an intermediate station (50) for dielectric preheating of said compacted sheet is arranged between said third vibro-compaction station (40) and said final hardening station (60).

7. Plant according to Claim 6, characterized in that said preheating station (50) uses electromagnetic waves with a frequency of less than 300 MHz.
8. Plant according to Claim 7, characterized in that electromagnetic waves having a frequency of between 25 and 35 MHz are used in said preheating station (50).